

Work Order ID 58718

Tuesday, May 18, 2010 8:01:31 AM



Page 1

Item ID: D3240-1

Accept



Setup Start



Revision ID:

Item Name: Frame

Stop



Start Date: 5/17/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: PH Date: 10-5-18 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3240

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3240 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024 .063

10-5-18

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-5-18

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/18

(+4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58718

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Frame

Start Date: 5/17/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

w/AS

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

w/ 10/05/19

X4

Hand Finishing

150



QC

QC3- Inspect Part Finish

Memo

0.00

0.00

④ BR 10-5-19

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 18, 2010 8:01:36 AM

Page 1

Work Order ID: 58718



Parent Item: D3240-1



Parent Item Name: Frame

Start Date: 5/17/2010

Required Date: 5/21/2010

Comments: IPP B 05.04.28 Added Step 6 & 7 KJ/JLM
IPP Rev C now water jet 07-11-01 DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	172.5000	2.534	12,		



2024-T3 .063 sheet



HB 10-5-10

Location

Loc Qty

Loc Code

MAT22

172.5

111787

2

113866

19.2

113867

19.1

114351

132.2

113867

(4)

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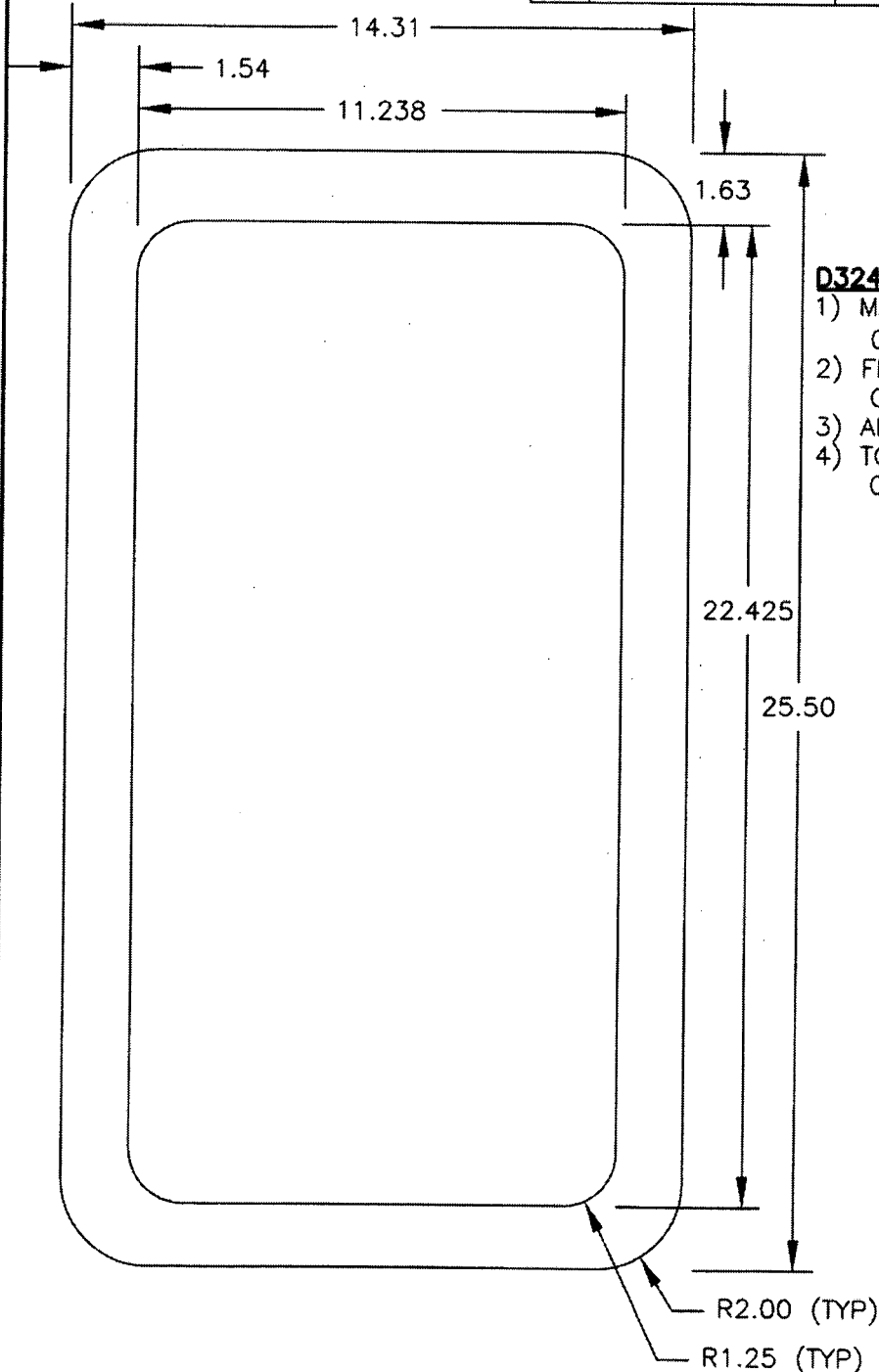
DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3240	REV. B SHEET 1 OF 1
DATE 05.01.06		TITLE FRAME	SCALE NTS
A	03.12.18	NEW ISSUE	
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19	

RELEASED
05-02-02 *[Signature]***D3240-1 FRAME**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4),
0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION
COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI
018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 38718

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